

Work Order ID 66354

Friday, February 11, 2011 10:56:39 AM

PRELIMINARY ISSUE

Page 1

Item ID: D4317-5

Accept

Revision ID: PRELIM

Item Name: GPS Plate

Start Date: 2/11/2011 Start Qty: 1.00

Required Date: 2/15/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4317

PA1

100

0.00



Waterjet

FLOW CNC Waterjet

304 - 063

Memo

0.00

1-Cut as per Dwg

Dwg Rev: PA1

Prog Rev: PA1

2-Deburr if necessary

B11-2-14

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B11-2-14

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Page 2

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Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00 - inspect to PA1

0.00 Dry only

0.00 Sulfuric

Memo

QC

Quality Control

130

Identify as per dwg & Stock Location: B/C

0.00

0.00

Memo

Packaging

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

QC

Quality Control

Used
on
66051

POSITIVE RECALL

EFFECTIVE 11-02-11 AUTH U

RELEASED DATE

MF
11-02-15

Picklist Print

Friday, February 11, 2011 10:56:36 AM

Page 1

Work Order ID: 66354

Parent Item: D4317-5

Parent Item Name: GPS Plate



Start Date: 2/11/2011

Required Date: 2/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.02.02 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	128.3800	0.3906	0.411158			



304/316 Sheet .063



1B 11-2-14

Location

Loc Qty

Loc Code

MAT

128.38

111323

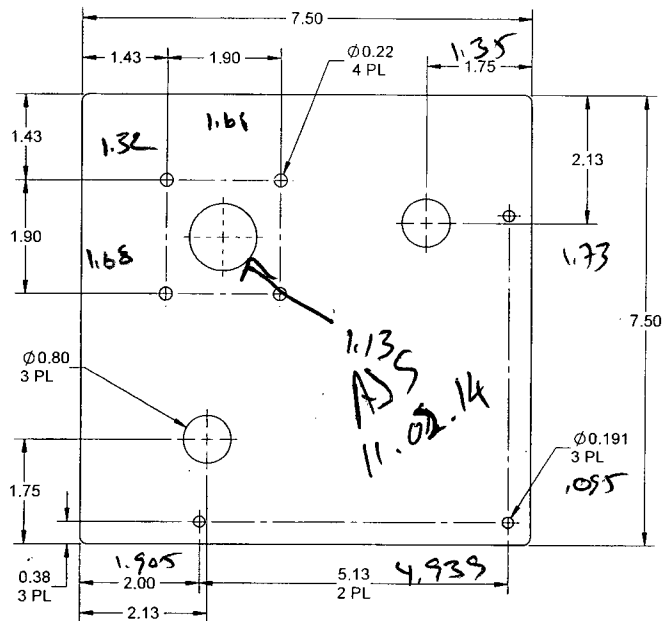
0

116623

128.38

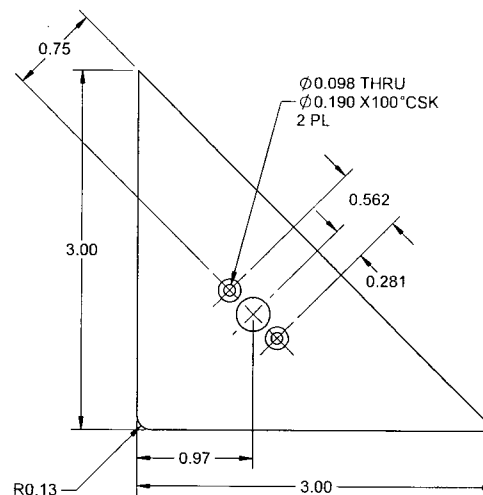
116623

①

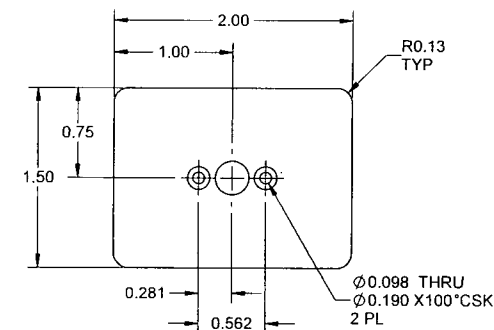


D4317-5 GPS PLATE

D4317-7 GPS PLATE



D4317-9 PLATE



D4317-11 PLATE

NOTE:

1) MATERIAL -5, -7, -9 & -11: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.060 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA OR DART SPEC M304S16GA

17-A1S1 4130N STEEL SHEET, 0.060 THK
PER MIL-S-18729 OR AMS 6350 OR AMS 6351
REF DART SPEC M4130N-S.060

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NA
- 7) WEIGHT -5 & -7: 0.97 lbs
-9 & -11: SEE ASSEMBLED WEIGHT

PRELIMINARY A1
11.02.01 (AJS)

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4317	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		VIEWING PLATE	NTS
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